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D350-588-011
Job Sheet 201773



Part No: D350-588-011

Job Qty: 3 pcs

Part Name: Aft Door Fwd Hinge Modification



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9690 REV A , DSI9760-011 REV A , D350-588 REV D IPP Rev:M 04.08.31 Added D2690-17 KJ/JLM
IPP REV:G 14.04.28 AS PER DSI9690 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	3 pcs	10/18/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
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							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Oscar
(012551)



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Container No: S225479



Part: D350-588-011

Job No: 201773

Serial No/Batch: S225479

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-41 Issue 8, FAA STC SH1012N

130 - Identify as per dwg & Stock Location:

135 - Document Control - Photocopy bluefile and create labels per PPP D350-588-011 CHG002

140 - QC21- Final Inspection - Work Order Release

(012551)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN526C1032R7	Screw	6 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	S113851 ✓
AN526C832R6	Screw	24 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	S115606(23) ✓ 0063136-1 ✓
AN526C832R9	Screw	24 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	S163236 ✓
D2143	Hinge Bracket	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	F156245 ✓
D2144	Hinge Doubler	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S061022 ✓
D2150	Packer Doubler, Hinge	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S100799 ✓
D2151	Packer Doubler	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S061788 ✓
D2153	Door Prop	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S222187 ✓
D2154	Bracket, Stud	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S096799 ✓
D2237	Striker Plate	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S216874 ✓
D2461	Neoprene 'D' Seal (\$Per Foot) 3(1ea)	21.7500 ft (7.25 ea) ✓	110-Packaging 1 - Pick Kit	S139720 ✓
D2463	1/2" Seal (\$ Per Foot) 3 (1ea)	21.7500 pcs (7.25 ea) ✓	110-Packaging 1 - Pick Kit	S126956 ✓
D2583	Latch Bracket	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S212398 ✓
D2585	Latch Clamp	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S199061 ✓
D2586	Door Latch	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S193760 ✓
D2587	Door Plug	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S1840 ✓
D2589	Keys, Key Chain	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S132942 ✓
D2690-17	Cable	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S209885 ✓
D2857-1	Hinge Bracket	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S213160 ✓
D2857-2	Hinge Bracket	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S213784 ✓
D2858-1	Hinge Bracket	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S214440 ✓
D2858-2	Hinge Bracket	3 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S152164 ✓
D5080-047	Striker Plate Assembly	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S28998 ✓
FG-778150-550-ROI	7781 9 oz Glass 50" x 125 yd	3 sf (1 ea) 12" x 12" ✓	110-Packaging 1 - Pick Kit	S134084 ✓
MS20426AD3-4	Rivet	36 Ea (12 ea) ✓	110-Packaging 1 - Pick Kit	F136444 ✓
MS20470AD4-5	Rivet, Universal Head	54 Ea (18 ea) ✓	110-Packaging 1 - Pick Kit	S198109 ✓
MS21042L08	Nut	54 Ea (18 ea) ✓	110-Packaging 1 - Pick Kit	S205000 ✓
MS21042L3	Nut	12 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	S211533 ✓
MS27039-08-11	Screw	6 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	F138336-10 ✓
MS27039-11-15	Screw	6 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	S114920 ✓
NAS1149D0363J	Washer	12 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	S201031 ✓
NAS1149DN832J	Washer	72 Ea (24 ea) ✓	110-Packaging 1 - Pick Kit	S185074 ✓

DAS
35
9-89

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN526C1032R7	6	76	0
	AN526C832R8	24	175	0
	AN526C832R9	24	262	0
	D2143	3	4	0
	D2144	3	3	0
	D2150	6	11	0
	D2151	6	10	0
	D2153	3	5	0
	D2154	3	7	0
	D2237	6	22	0
	D2461	22	245	0
	D2463	22	410	0
	D2583	6	35	0
	D2585	6	25	0
	D2586	6	19	0
	D2587	3	23	0
	D2589	3	134	0
	D2690-17	3	5	0
	D2857-1	3	22	0
	D2857-2	3	18	0
	D2858-1	3	22	0
	D2858-2	3	28	0
	D5080-041	6	10	0
	FG-778150-550-ROL	3	1,710	0
	MS20426AD3-4	36	1,761	0
	MS20470AD4-5	54	1,987	0
	MS21042L08	54	1,041	0
	MS21042L3	12	2,983	0
	MS27039-08-11	6	1,041	0
	MS27039-1-15	6	189	0
	NAS1149D0363J	12	401	0
	NAS1149DN832J	72	872	0
Part Specifications				
Specifications could not be found.				

Plex 10/10/19 12:56 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042)									
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition											
Description Work Order Deviation						Completed By											
						Lead hand / Supervisor											
						QC / QA Coordinator											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1	1	D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2	2	D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

Change Record

PAGE 1 OF 1

Part Number: D350-588-011

Description: AFT DOOR FWD HINGE MODIFICATION INSTALLATION

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